



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

002664

Ship May 1

DSI 9342-011
Job Sheet 176093



Part No: DSI 9342-011

Job Qty: 1 ea

Part Name: Gusset Repair



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 4/17/18

Job Tracking No:

Due Date: 5/1/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DSI 9342-011 REV.B IPP REV:A 18.04.17 AS PER DWI REV.B DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup	Run	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		5/1/18	0.00	0.00	Start Up Stores/Pkg-2		APR 20 2018
110	Packaging	1 pcs		5/1/18	0.00	0.00	Packaging1-5		APR 20 2018
120	QC	1 pcs		5/1/18	0.00	0.00	QC4		
125	DC	1 pcs		5/1/18	0.00	0.00	DC		DAS
130	Packaging	1 pcs		5/1/18	0.00	0.00	Packaging3-2		58
140	QC21-FG	1 Ea		5/1/18	0.00	0.00	QC21		9-89 DAS 58 APR 20 2018

Part Op 125 - Photocopy bluefile & type labels per PPP DSI 9342-011 CHG001

Descriptions: 130 - Identify and pack for shipping as per PPP DSI 9342-011 Location : FG123 PPP rev: _____

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN4-15A	Bolt	4 Ea (4 ea)	90-Start up Operation	5057424
D3929-041	Gusset Assembly	2 Ea (2 ea)	90-Start up Operation	5037918
D3929-042	Gusset Assembly	2 Ea (2 ea)	90-Start up Operation	5037911
MS21042L4	Nut	4 Ea (4 ea)	90-Start up Operation	3045901
NAS1149D0463J	Washer	8 Ea (8 ea)	90-Start up Operation	5045845

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	AN4-15A	4	487	0
	D3929-041	2	2	0
	D3929-042	2	2	0
	MS21042L4	4	3,229	0
	NAS1149D0463J	8	4,881	0

Part Specifications

Specifications could not be found.

Plex 4/17/18 8:32 AM Dart.lajeunesse.marie

8063164

Change Record

Part Number	DSI 9342-011
Description	GUSSET REPAIR KIT

Page 1 of 1

[illegible]

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment ☐		No Re-verification ☐		Pressure/Forced ☐		Temperature/Cure ☐	
Design ☐		Operator ☐		Bending ☐		Set-up ☐	
Doc/Data ☐		Offset/Setup ☐		Centre Not Concentric ☐		BOM/Route ☐	
Equip/Tooling ☐		Supplier ☐		Cracks ☐		Broken/Damage/Defect ☐	
Handling/Pre ☐		Training ☐		Crimp/Kink/Ripple/Wave ☐		Inspection Incomplete/Unqualified ☐	
Material ☐		Use for Testing ☐		Cuffs ☐		Contamination ☐	
Internal Transport ☐		Poor Information ☐		Crushing ☐		Countersink ☐	
Tribal Knowledge ☐		Rushing ☐		Heat Treat ☐		Cut Too Short ☐	
LOA ☐		Product Improvement ☐		Wave/Twist in Tube ☐		Instructions Incomplete/Unclear ☐	
Substation ☐		Process Improvement ☐		Marks/Chatter ☐		Drill Holes ☐	
Past Expiry Date ☐		Manufacturing Process ☐		OTHER : _____			
Misidentified ☐		Past Due ☐					

DART SERVICE INSTRUCTION

TO AMEND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-607

REF. CANADIAN STC: SH94-14

REF. FAA STC: SR00213NY

REF. EASA STC: EASA.IM.R.S.01405

IN CASES WHERE THE D2325 GUSSETS HAVE SUSTAINED CONSIDERABLE DAMAGE, DSI 9342-011/-013 REPAIR KITS CAN BE PROCURED FROM DART TO REWORK EXISTING D350-607-041/-043 BASKET BASES ONLY. D350-607-045/-047 BASKET BASES CANNOT BE REWORKED TO THIS PROCEDURE. REPLACE THE D2325 GUSSETS BY T.I.G. WELDING AS FOLLOWS:

- 1) CLEAN AREA OF PAINT, ETC...
- 2) REMOVE EXISTING D2325 GUSSET(S) AS SHOWN IN FIGURE 1.
- 3) INSTALL REPLACEMENT D3929-041/-042 GUSSETS BY T.I.G. WELDING PER MIL-STD-2219/AMS-STD-2219 CLASS 'C' USING ER308L FILLER ROD AS SHOWN IN FIGURE 2.
- 4) TOUCH UP PAINT IN ACCORDANCE WITH ICA-D350-607 REV 0.
- 5) WHEN BASKET BASE IS REPAIRED, LONGER BOLTS OR QUICK RELEASE PINS ARE REQUIRED TO INSTALL THE BASKET ON AIRCRAFT. SUBSTITUTE EXISTING HARDWARE USING PARTS LISTED BELOW.
- 6) ADJUST WEIGHT AND BALANCE IN ACCORDANCE WITH THE TABLE ON SHEET 4.

PARTS LIST

QTY. -011	QTY. -013	PART NUMBER	DESCRIPTION
X		DSI 9342-011	GUSSET REPAIR KIT
	X	DSI 9342-013	GUSSET REPAIR KIT, QUICK RELEASE
2	2	D3929-041	GUSSET ASSY, LH
2	2	D3929-042	GUSSET ASSY, RH
4		AN4-15A	BOLT (REPLACES AN4-12A)
8		AN960JD416	WASHER
	4	BLRS-020	QUICK RELEASE PIN (REPLACES BLRS-010)
4		MS21042L4	NUT

CANADA DEPARTMENT OF TRANSPORT AIRCRAFT CERTIFICATION BRANCH DAO # 01-O-01	
APPROVED	
BY: 	
D. SHEPHERD (DE # 02)	
DATE: 09.04.06	
CERT. NO.: SH94-14	
ISSUE NO.: 4	

B	CREATION OF DSI KITS TO PROVIDE REPLACEMENT PARTS AND REQD HARDWARE. SEE NCR#09-042.	MB	09.04.06
A	NEW ISSUE	PH	06.07.10
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. B
MFG. APPR.	N/A	DSI 9342	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE WELD REPAIR	NTS
DATE	09.04.06	COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	